JUNE 30 OV Sound *103122*

Work Order ID 103122

June-14-13 9:14:12 AM

Page 1

Item ID: Revision ID: Item Name:	D4130-9 Aft Cargo Flo	oor Protector		Accept	*N	900	04 0	100) *	Setup Star Stop	17	S1* S2*
Start Date: Required Date: Reference:	6/14/13	Start Qty: 13.00 Req'd Qty: 13.00	*13* *13*			Cust Item ID: Customer:					I	
Approvals:	Process Pl	an: MLJ	Date: 13-06-14	Tooling:	·	Da	nte:		F	Run Star	"IV	R1*
	QC:		Date:	SPC (Y/N):		Date:				Stop	` *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	.]	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr			· · · · · · · · · · · · · · · · · · ·							
D4130	В					:						•
*100 *100* Waterjet FLOW CNC Waterj	et	<u> </u>	<u>& </u>	0.00	*	1			_/3	EC	/3	-6-27
*110 *110* QC Quality Control		QC2- Inspect parts off ma	chine FAI/FAIB	0.00					-3		'_/3·	6-37
120 *120* QC Quality Control		QC8- Inspect parts - secon	d check	0.00	2	;			B			

DQA:			Date:											
			·			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		, , , , , , , , , , , , , , , , , , , ,
Work Ord	er:			•		DISPOSITION			AGAINS	T DÉ	PARTMENT	/PROCESS		
						Rework	1		Skid-tube Crosstube	Water Jet			Engineering	
Part i	Vo.					Scrap	.		Machining Small Fal	<u> </u>	Prod. Eng. Coor.			Quality
					_	Use-as-is			noforming Finishin	-	- i	re/Packaging		Other
NCR !	No.					Suspected Unapproved				Supplier				
Root			ļ		Desc	ription of work order update	on of work order update Initial Action				Sign &			
Cause		Date	Step	Qty	Desci	or non-conformance	ı	ief Eng	1		Date	Verification	,	QC Inspector
Design	-		0.00	~.,				,8						
Doc/Data		· .												
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup]				1							
Process														
Supplier														
Training														
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Unapproved														
A							FA	ULT CA	TEGORY					
Landi	ng (Sear				General		1			-	-		1
		Bending		*		Bend		1	Program		Outside Dim	+		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	-f		Set-up
		Cracks				Broken/Damage/Defect	_	Hardwa		\perp	Part Incorred	F	_	Temperature/Cure
	_	Crimp/Kin	nk/Ripple,	/Wave		Burrs	<u> </u>	1	ion Incomplete/Unqualified	\perp	Part Lost/Mi			Weld
	$\overline{}$	Cuffs			<u> </u>	Contamination		1	tions Incomplete/Unclear	\vdash	Part Moved			Wrong Stock Pulled
	Crushing				<u> </u>	Countersink	_	•	gned/off center	\vdash	Positioned V		1	
	Heat Treat				Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge [Other	
	Inspection Strip in Tube				Drawing	<u> </u>	Misread							
	Marks/Chatter			÷	<u> </u>	Drill Holes		Off-set						
	Turning Sequence				-	Finish	L	1	Calibration					
	Wave/Twist in Tube			e		Fit/Function		Out of S	Out of Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

June-14-13 9:14:12 AM

Item ID: D4130-9 Accept *N900040100* Setup Start **Revision ID:** Item Name: Aft Cargo Floor Protector **Start Date: Start Oty: 13.00** 6/14/13 **Cust Item ID:** Required Date: 6/28/13 Req'd Oty: 13.00 **Customer:** Reference: Run Process Plan: _____ Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Mumber Stamp 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo **Packaging** 140 QC21- Final Inspection - Work Order Release 0.00 MUS 1306-28 QC 0.00 Memo Quality Control

DQA:		_ Date:			TAART							
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		ork Order up	odate only	AEROSPACE
	•				DISPOSITION					· · · · · · · ·	<u> </u>	
Work Orde	er:		. <u></u>	_	DISPOSITION	AGAINST DEPARTMENT/PROCESS						
					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo			_	Scrap					Quality		
					Use-as-is	↓	Therr	moforming	· -	Finishing Rec/Store/Packaging		
NCR N	lo			-	Suspected Unapproved]		Large Fab	Composite Supplier Supplier			
Root				Descrip	tion of work order update		nitial	Acti	on	Sign &	,	1
Cause	Date				or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design							· · · ·		 	1		
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material								1				
Operator												
Offset/Setup												
Process						'					:	
Supplier												
Training												
Transport												
Unapproved					ATT - 22							
						FAI	ULT CA	TEGORY				
Landin	ng Gear				General	_	-			_		_
	Bending			В	end		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric	В	OM/Route		Grain	·		Over/Under	tolerance	Set-up
	Cracks			В	roken/Damage/Defect		Hardwa	are		Part Incorred	ct L	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave	B	urrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	Cuffs				ontamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	Crushing				ountersink		1	gned/off center		Positioned V		_
	Heat Tre				ut Too Short		Mislabe	eled	, L	Power Loss/	Surge	Other
	Inspection	n Strip in	Tube	ШD	rawing		Misrea	d				
ļ	Marks/C			ШD	rill Holes		Off-set					
. [i	Sequence		\vdash	nish		Out of	Calibration				
1	Wave/Twist in Tube		Fi	it/Function		Out of	Sequence					

Picklist Print

June-14-13 9:14:16 AM

Work Order ID: 103122

D4130-9

Parent Item Name: Aft Cargo Floor Protector

103122

D4130-9

Start Date: 6/14/13

Required Date: 6/28/13

Start Qty: 13.00

Required Qty: 13.00

Comments:

Parent Item:

IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	_	imary ecation	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	 No			100	sf	1,238.362	5.882	80.49053			·
*MI FXS 1	25-F60	N29 ₋ N4	*					1,20000	**	60.49033	. 3	,	:

MI FXS 125-F60029-04
GE PLASTICS LEXAN SHEET

EZ 13-6-27

Location Loc Oty Loc Code MAT018 1238.362 124866 1238.362

DQA:		Da1	te:										
			,		WORK ORDER NON	1-C	ONFO	RMANCE / UPDATE				AEROSPACE	
QA Closed:		Da1	te:						W	ork Order up	date only		
Work Orde				na sy	DISPOSITION			AGAINS					
Work Orde	··· ——		· · · · · · · ·		Rework	٦		Skid-tube Crosstub	۔	1	Water Jet Engineering		
Part N	rt No				Scrap	\dashv		Machining Small Fa		Pro	d. Eng. Coor.	Engineering Quality	
raiti		A	<u> </u>		Use-as-is	┨		noforming Finishin	-	1	e/Packaging	Other	
NCR N	lo.				Suspected Unapproved			Supplier	1 1				
	-			1 8					<u> </u>			. .	
Root				Des	cription of work order update		Initial	Action		Sign &			
Cause	Da	te Ste	p Q	ty	or non-conformance	Cł	nief Eng	Description		Date	Verification	QC Inspector	
Design				1									
Doc/Data						-	i.						
Equip/Tooling													
Handling/Pre	_												
Material							•						
Operator						ĺ		,	•				
Offset/Setup	\dashv	·				İ							
Process													
Supplier			į			ŀ							
Training.													
Transport Unapproved	\dashv		·.		•								
onapproved 1	<u> </u>					FΛ	III T CA	I TEGORY		·	<u> </u>	<u> </u>	
Landin	ng Gear				General		OLI CA	ILOOKI		******			
	Bendi	ng		Г	Bend]Folio/F	Program	. [Outside Dim	ensions [Pressure/Forced	
ţ		e Not Con	centric	<u> </u>	BOM/Route		Grain		\vdash	Over/Under	. 1	Set-up	
	Crack				Broken/Damage/Defect		Hardwa	ire	\vdash	Part Incorrec	<u> </u>	Temperature/Cure	
	Crimp	/Kink/Rip	ple/Wa	ve	Burrs		1	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination	Γ	1	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Crush	ing			Countersink		-3	ned/off center		Positioned W	/rong		
	Heat	Treat			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other	
. [Inspe	ction Strip	in Tub	e [Drawing		Misread	d	•	· .			
	Mark	s/Chatter		. [Drill Holes		Off-set						
	Turnii	ng Sequen	ce	. [Finish	Out of Calibration							
ļ	Wave	/Twist in 1	Tube		Fit/Function		Out of	Sequence					

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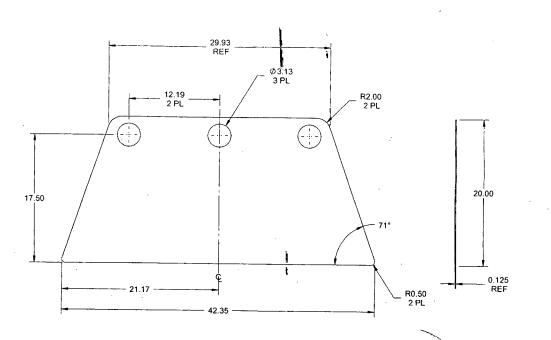
DART AEROSPACE LTD	Work Order:	103177
Description: Aft Cargo Floor Protector	Part Number:	D4130-9
Inspection Dwg: D4130 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.13	+0.012/-0.001	3.135		,	U JKMOI	
12.19	+/-0.030	12.195			T+V	
29.93	+/-0.030	29.43			1	
17.50	+/-0.030	17.48	,		7	
21.17	+/-0.030	27.155				
42.35	+/-0.030	42.71			1	
20.00	+/-0.030	20	V		7	
0.125	+/-0.010	0.125				
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				-		
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			CAS I			1

Measured by:	12	Audited by:		Preliminary Approval:	
Date:	13-6-27	Date:	13607	Date:	-

Rev	Date	Change	Rev	ised by	Approved
. <u>A</u>	10.10.25	New Issue	KJ	1/	
В	12.05.15	Dwg Rev updated	KJ	4	11/1
				-//	- Company of the Comp



103122 MLJ 13-06-14

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Reach Degrad To a NEW tending A Skirl of P COER

D4130-9 AFT CARGO FLOOR PROTECTOR (TEXTURED SIDE SHOWN)

NOTES: 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE
7) WEIGHT: 3.78 lbs

8

DESIGN	HS	DART AEROSPACE US	A INC.			
DRAWN	RF	KENT, WA	., .,			
CHECKED	14	DRAWING NO.	REV. B			
MFG. APPR.	\overline{N}	D4130	SHEET 5 OF 5			
APPROVED	NP.	TITLE	SCALE			
DE APPR.	-#	FLOOR PROTECTOR	NTS.			
DATE 11.0	7.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE DIVINESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PROPIOSE OR DOCUMENT OF TO MAY CHAPE PRESENT WITHOUT.				

3

DQA:			Date:										
						WORK ORDER NO	N-C	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or∙					DISPOSITION	÷						
WOIR Old		-				Rework	7 .		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap		Machining Small Fab			d. Eng. Coor.	Quality	
	_					Use-as-is	7		noforming	Finishing		re/Packaging	Other
NCR No.			Suspected Unapproved			Large Fab	Composite		Supplier				
							· · · · · · · · · · · · · · · · · · ·			·			
Root					Desci	ription of work order update		Initial	Acti		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Design			:									•	
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Equip/Tooling													
Handling/Pre													
Material -	Н												
Operator	H												
Offset/Setup	\dashv								1				
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Landi	ng Ge	ar				General							
		ending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	C	entre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	С	racks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure
	C	rimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	c	uffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
ı	C	rushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
:	Шн	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	∐ Ir	spection	n Strip in	Tube		Drawing		Misread	i				
	Ш∾	1arks/Ch	atter			Drill Holes	L	Off-set					
-	_	-	equence			Finish		Out of 0	Calibration				
	Wave/Twist in Tube			oe		Fit/Function	_L	Out of S	Sequence				